

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011894**Date Inspected:** 12-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**TRIAL ASSEMBLY YARD**

This QA Inspector randomly observed the following work in progress.

**OBG SEGMENT 7CW**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 069683 performing Shielded Metal Arc Welding process for weld CA035-002 located on PCMK the weld between deck panel and edge panel counter weight side of OBG segment 7CW. ZPMC QC Mr. Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

**OBG SEGMENT 7BW**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068917 performing Shielded Metal Arc Welding process for weld CA035-006 located on PCMK the weld between deck panel and edge panel counter weight side of OBG segment 7CW. ZPMC QC Mr. Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

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### OBG SEGMENT 7CW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066746 performing Flux Cored Arc Welding process for weld SP430-001-34 located on PCMK side panel “T” rib stiffener to “T” rib stiffener (counter weight side) at the splice weld between OBG segment 7BW and 7CW. ZPMC QC Mr. He Yan Bing monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2233-B-U2-F.

### OBG SEGMENT 6CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066763 performing Shielded Metal Arc Welding process for weld CA028-002 located on PCMK the weld between deck panel and edge panel (bike path side) in OBG segment 6CE. ZPMC QC Mr. Zhong Guo Hui monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW -3G (3F)-FCM-Repair-1. Critical weld report identified as B-CWR1137.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067610 performing Shielded Metal Arc Welding process for weld CA028-004 located on PCMK the weld between deck panel and edge panel (bike path side) in OBG segment 6CE. ZPMC QC Mr. Zhong Guo Hui monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW -3G (3F)-FCM-Repair-1. Critical weld report identified as B-CWR1137.

### OBG SEGMENT 7AW

This Quality Assurance (QA) Inspector observed ABF Inspector performing Ultrasonic Inspection on the corner weld between deck panel and edge panel (counter weight side) of OBG segment 7AW.

This Quality Assurance (QA) Inspector observed ABF Inspector performing Ultrasonic Inspection on the corner weld between deck panel and edge panel (cross beam side) of OBG segment 7AW.

### OBG SEGMENT 7BE

This Quality Assurance (QA) Inspector observed ABF Inspector performing Ultrasonic Inspection on the corner weld between deck panel and edge panel (Bike path side) of OBG segment 7BE.

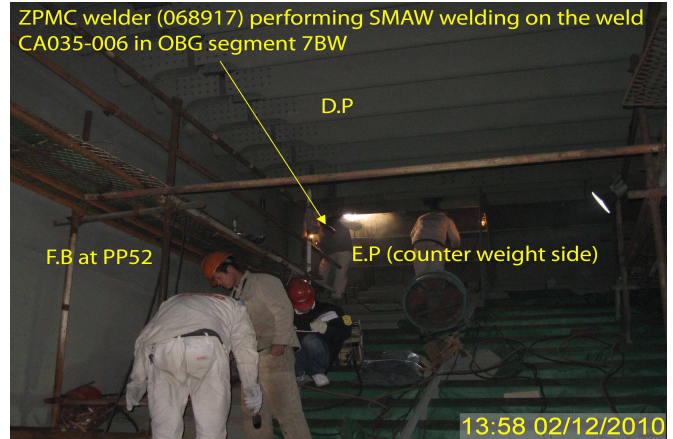
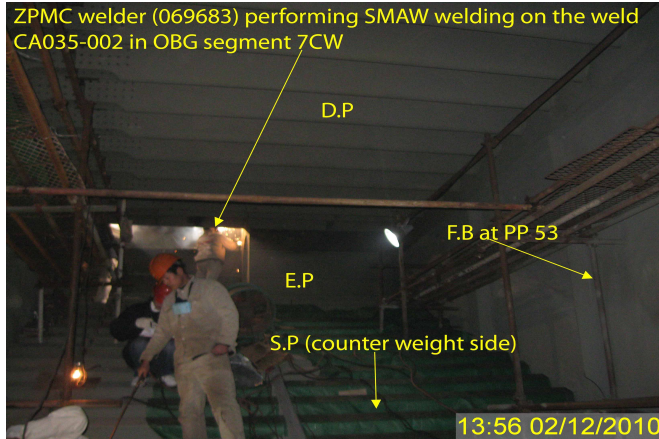
Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Dawson,Paul

QA Reviewer